

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011065**Date Inspected:** 06-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Qi Guo, Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER / OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

HEAVY DOCK

This QA Inspector randomly observed the following work in progress.

WEST TOWER LIFT # 1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040736 performing Flux Cored Arc Welding process for weld WSD1-SA279-08 located on PCMK the weld between P397 and P1144 on skin B of West tower lift 1. ZPMC QC Mr. Yu Qi Guo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053486 performing Flux Cored Arc Welding process for weld WSD1-SA279-04 located on PCMK the weld between P378 and P169 on skin B of West tower lift 1. ZPMC QC Mr. Yu Qi Guo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 202821 performing Flux Cored Arc

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Welding process for weld WSD1-SA279-15 located on PCMK the weld between P169 and P3884 on skin B of West tower lift 1. ZPMC QC Mr. Yu Qi Guo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 062092 performing Shielded Metal Arc Welding process for weld SEG032-043 located on PCMK weld between deck panel and edge panel cross beam side near PP47 in OBG segment 6CE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-TC-U4B-FCM.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld SEG030B-011 located on PCMK weld between bike path side longitudinal diaphragm and floor beam at PP41 in OBG segment 6BE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F) FCM-Repair-1. The weld repair report identified as B-WR9695.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
